

4

Date: Monday, 1/7/2008 11:43:54 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW KIT (19"X24")
Job Number : 36613	
Estimate Number : 12618	
P.O. Number :	Part Number : D427659011
This Issue : 1/7/2008 S.O. No. :	Drawing Number : D2432 REV F3
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : F3
Previous Run : 36583	Material :
Written By :	Due Date : 1/25/2008 Qty: 4 Um: Each
Checked & Approved By : <u>08.01.07</u>	
Comment : Est Rev:A New Issue 07-01-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D427-659-011 CHG001

K.S. 08/01/18

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 6.8250 sf(s)/Unit Total : 27.3000 sf(s)
 blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5
 Material: Black UHMW 1"

(MUHMWB10)

Batch: M106717

J.L. 08/01/14

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

J.L. 08/01/14/DJP

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

D.J.P./J.L. 08/01/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 11:43:54 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 36613

Part Number: D427659011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 02/01/16

8

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.5000 f(s)/Unit Total : 10.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050

Rubber Cushion

334777

SP

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274

Radius Block

332852

2 D2432F(ref only)

Bearpaw

36613

SP

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438

Clamp

332016

SP

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529

Washer

335356

8/1/18 SP (4X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BEARPAW KIT (19"X24")

Job Number: 36613

Part Number: D427659011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Batch:

M104745

SP

12.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416

Washer

M105906

SP

13.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M103054

SP

14.0

D2732

Rubber Extrusion



Comment: Qty.: 2.5000 f(s)/Unit Total : 10.0000 f(s)

Rubber Extrusion

6 x Pieces at 5"

Batch:

B39717

26 7/2

5/1/18 SP (4)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

12 08/01/18

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD427-659-011

Location:

Rev A

AS 08/01/18

(XV)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08-01-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		/					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 36613
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.07x45°	✓			
B	5.500	+/-0.030	5.501	✓			
C	0.200	+/-0.030	.195	✓			
D	0.25 x 45°	+/-0.030	.248x45°	✓			
E	R0.250	+/-0.030	.250	✓			
F	0.250	+/-0.010	.254	✓			
G	0.625	+/-0.030	.630	✓			
H	0.375	+/-0.010	.378	✓			
I	0.950	+0.030/0.010	.950	✓			
J	19.000	+/-0.030	19.00	✓			
K	3.14	+/-0.030	3.143	✓			
L	3.28	+/-0.030	3.290	✓			
M	Ø0.260	+0.005/-0.000	.260	✓			
N	Ø0.93	+/-0.030	.930	✓			
O	0.30	+0.030/-0.000	.310	✓			
P	23.750	+/-0.030	23.75	✓			
Q	7.375	+/-0.030	7.370	✓			
R	4.250	+/-0.010	4.250	✓			
S	2.000	+/-0.030	2.010	✓			
T	9.000	+/-0.010	9.00	✓			
U	9.000	+/-0.010	9.00	✓			
V	0.375	+/-0.010	.376	✓			

Measured by: SL	Audited by: SF	Prototype Approval: N/A
Date: 08/01/14	Date: 08/01/14	Date: —

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015 KJ/RF	TF

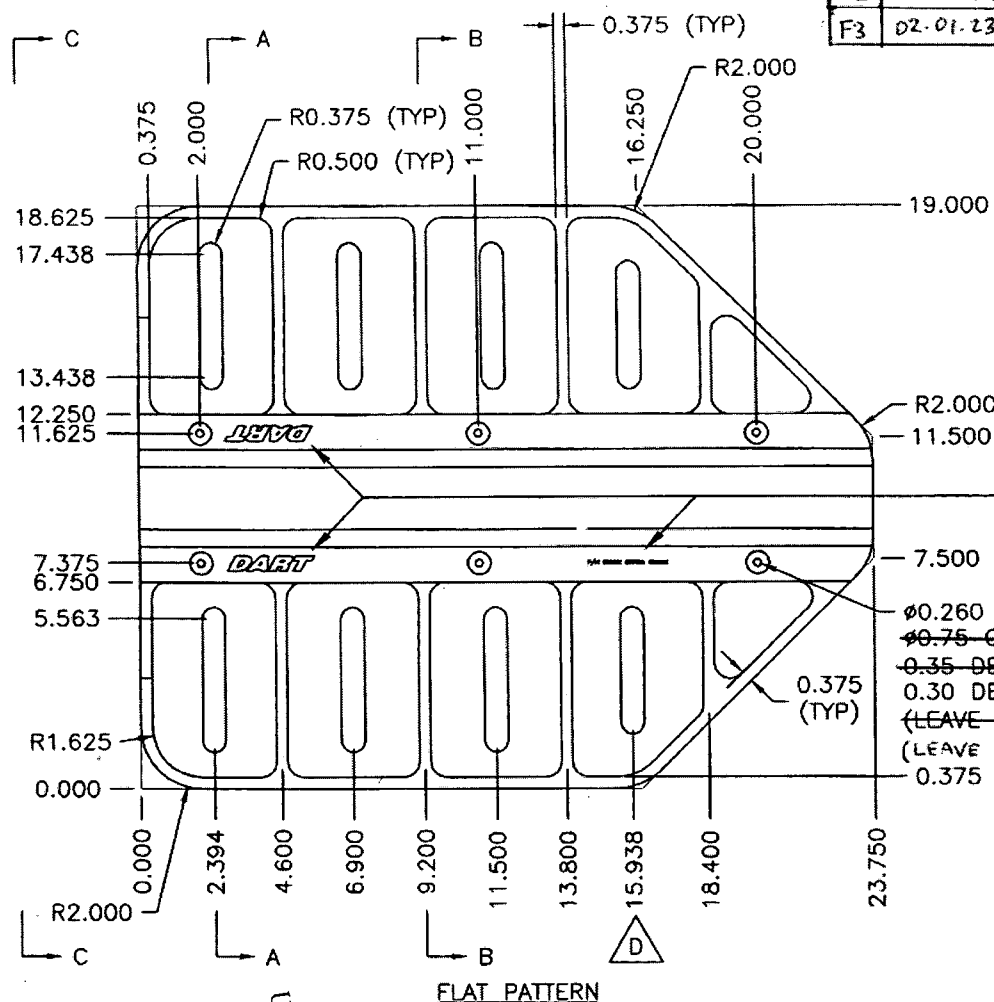
DART



RELEASED
98.06.17 KE

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



Ø0.260 (TYP)
Ø0.75 C'BORE Ø0.93 C'BORE
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)

EFFECTIVE	DEOS
9143	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	KE	
CHECKED	APPROVED	DRAWING NO.
MM	AS	D2432
DATE	TITLE	SHEET 1 OF 2
98.05.12	BEARPAW	SCALE 1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

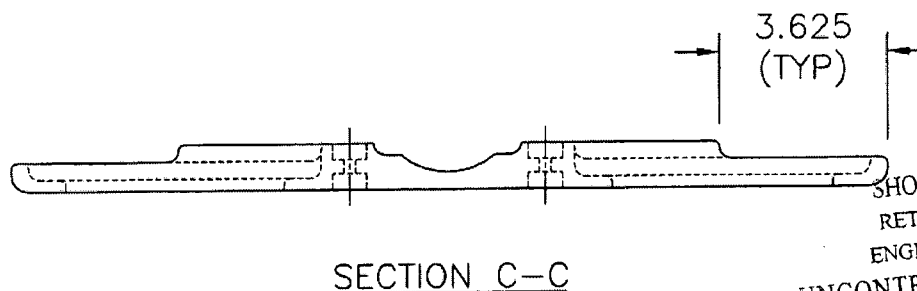
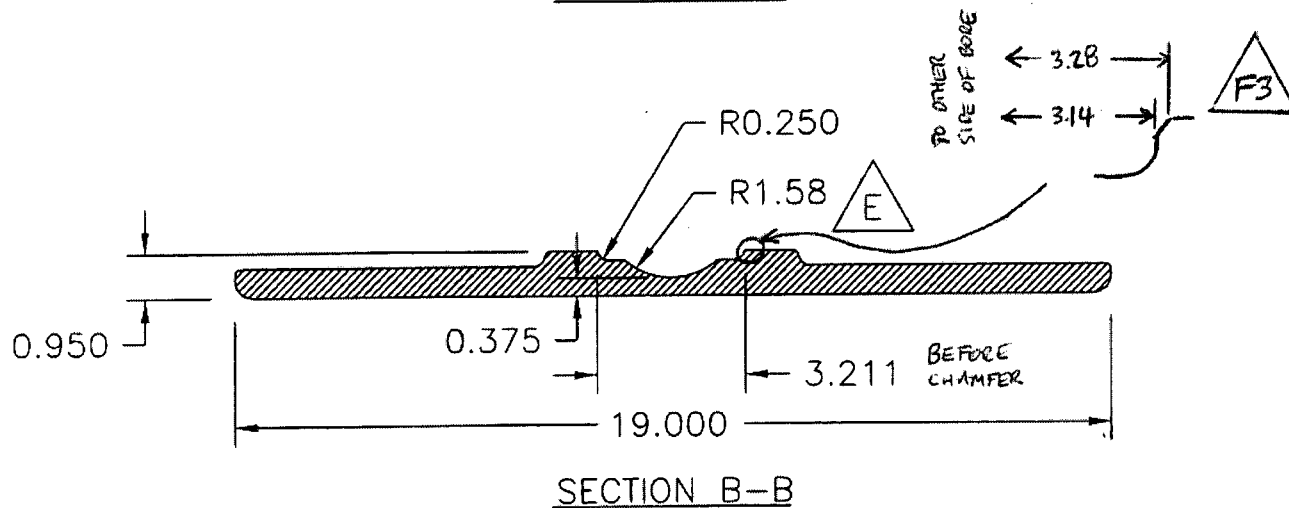
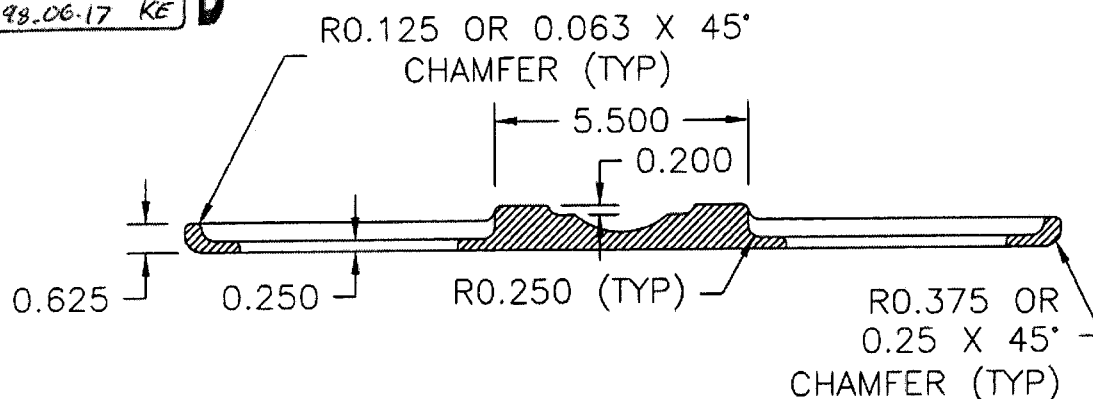
NO. 26613
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED
98.06.17 KE



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